

Date: Monday, 3/6/2006 1:55:44 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HINGE BRACKET PLATE
Job Number	: 26077		
Estimate Number	: 10199		
P.O. Number	: N/A	Part Number	: D2179
This Issue	: 3/6/2006 S.O. No. N/A	Drawing Number	: D2179 REV. B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: N/A	Material	: N/A
Written By	: <u>SRE COMMENT BELOW</u>	Due Date	: 1/5/2006
Checked & Approved By	: <u>06.03.06</u>	Qty:	100 Um: Each
Comment	: Est A 00.07.0 New Issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S040	5052-H32 .040 Sheet
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Comment: Qty.: 0.0096 sf(s)/Unit Total : 0.9555 sf(s)

Material: 5052-H32 (or 6061-T6) 0.040" thick
 (M5052H32S.040)

Batch: M15982ml 06/03/15

(100)

2.0	SHEAR	SHEAR
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Comment: SHEAR

Cut blank: 1.645" x 0.800"

ml 06/03/15 2ty 125

(100)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: ~~HAAS CNC VERTICAL MACHINING #1~~

Machine as per Folio FA080 and Dwg D2179
 Identify as D2179

HAND MADEand deburrml 06/03/00 2ty 94

PTO

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

N/A

5.0	QC2	SECOND CHECK
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Comment: SECOND CHECK

06.03.2004

(36)

6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble and Deburr

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2179 PAR #: N/A Fault Category: Red / FAB. ASS' most small NCR: Yes No DQA: [Signature] Date: 06/04/10
 QA: N/C Closed: [Signature] Date: 06/04/10

NCR: <u>26077</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/03/20	03	Scrap 31 parts Holes off dimension	<u>[Signature]</u> 06/03/20	destroy them No replace	<u>[Signature]</u> 06/03/20	<u>[Signature]</u> 06-03-28	<u>[Signature]</u> 06/03/28	<u>[Signature]</u> 06-03-28
06-03-28	03	56 parts no good, holes too close together by .025" → .035" will spread holes open during ass'y causing tearing in the mat'l.	<u>[Signature]</u> 06/03/28	Scrap, NO replace	<u>[Signature]</u> 06-03-28	<u>[Signature]</u> 06-03-28	<u>[Signature]</u> 06/03/28	<u>[Signature]</u> 06-03-28

NOTE: Date & initial all entries

Date: Monday, 3/6/2006 1:55:44 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET PLATE

Job Number: 26077

Part Number: D2179

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

DL 06/03/29

(38)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-04-05

(38)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

MA

06 04 05

(38)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST027

AR 06/04/06

(38)

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

ED

06/04/10

(38)

Job Completion



u 06-04-10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	26077
Description: Hinge Bracket Plate	Part Number:	D2179
Inspection Dwg: D2179 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X

First Article

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Prototype

[illegible]

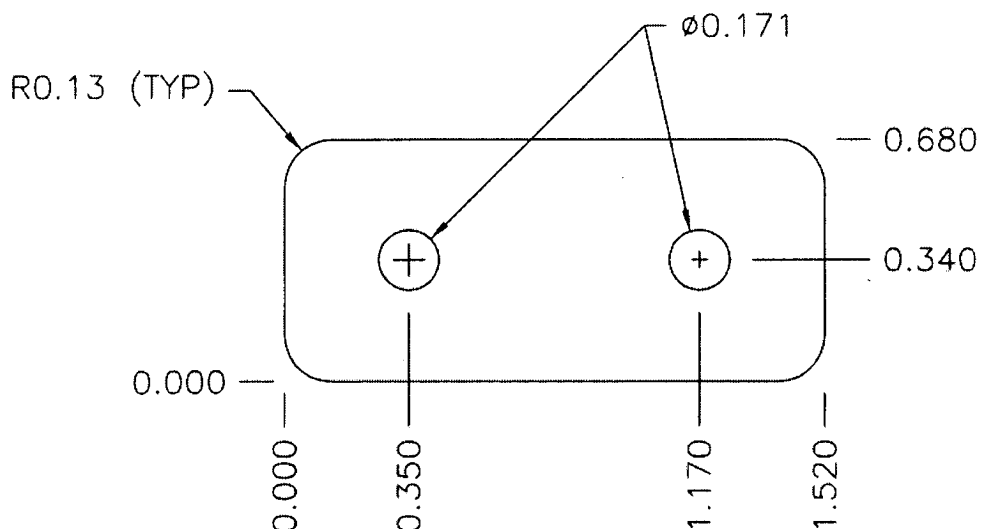
Measured by:		Audited by:		Prototype Approval:	N/A
Date:		Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.10.05	New Issue	K.J./JLM	



DESIGN KH	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2179	REV. B SHEET 1 OF 1
DATE 00.06.20		TITLE HINGE BRACKET PLATE	SCALE 2:1
A	95.03.17	NEW ISSUE	
B	00.06.20	DWG No. D2179 WAS D2399	

RELEASED
ord. 27 *[Signature]*



MATERIAL: 5052-H32 (QQ-A-250/8) OR 6061-T6 (QQ-A-250/11)
OR 2024-T3 (QQ-A-250/4) 0.040 THICK
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26077

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